

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 Rev. C AND  
INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D206-667 Rev. 2  
REF. CANADIAN STC: SH01-5  
REF. FAA STC: SR01304NY  
REF. EASA STC: EASA.IM.R.S.01179

For D407-667-205 High Aft Crosstube at CHG 007 or later, an inspection window has been added on the underside of the crosstube to facilitate inspection.

**IMPORTANT NOTE: If a D407-667-205 Crosstube was stripped of paint, it should now be refinished as follows:**

- 1) Apply chemical conversion film material (Alodine 1200 or 1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer.
- 2) Mask underside of crosstube as per hatched area shown in Figure 1.
- 3) Paint outside surfaces of crosstube by applying 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 4) Apply clear coat on inspection window (hatched area).

Additionally, for D407-667-205 High Aft Crosstube at CHG 007 or later, the D2856-400-773 Abrasion Strips have been removed and the D3190-1 Chafing Shields have been bonded onto the crosstube using Proseal 890. For D407-667-205 High Aft Crosstube at CHG 007 or later, amend Parts List of IIN-D206-667 Section 5.0 and ICA-D206-667 Section 32.8 as follows:

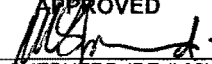
**Remove:**

Item	QTY -205	Part Number	Description
14	*2	D2856-400-773	ABRASION STRIP

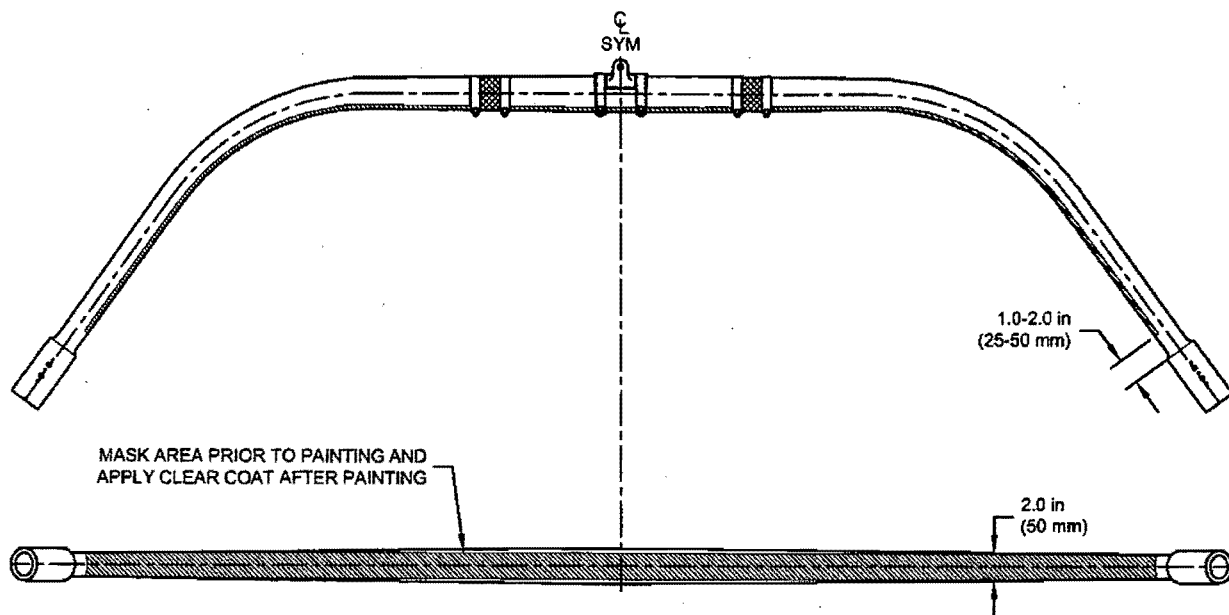
**If a D3190-1 Chafing Shield is being re-installed on the crosstube, it should now be re-installed as follows:**

- 1) Follow section 32.1 of ICA-D206-667 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty(2) MS21920-22 Clamps from the crosstube that fasten each D3190-1 Chafing Shield to the crosstube.
- 3) Remove the D2856-400-773 Abrasion Strips from the crosstube per section 32.5 of ICA-D206-667.
- 4) Inspect the crosstube surface where the chafing shields and abrasion strips were installed for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection. If crosstube was stripped of paint, refer to above instructions for suitable refinishing of crosstube.
- 5) Apply a 0.02" to 0.04" (0.5-1.0 mm) thick layer of Proseal 890 on the concave surface of D3190-1 Chafing Shields and let cure per manufacturer's instructions.
- 6) Once the Proseal on the D3190-1 Chafing Shields is cured, apply a thin layer of Proseal 890 on the crosstube to cover the area where the Chafing Shields will be installed.
- 7) Locate the D3190-1 Chafing Shield as shown in Figure 2. Ensure that the overlapping edge of the chafing shield is located at approximately 60° from bottom vertical to prevent deterioration of the rubber bumpers. Be sure to eliminate any air gaps.
- 8) Position and tighten the clamps to a torque of 80-100 in-lb (9.0-11.3 N-m).
- 9) Allow the assembly to cure for 12 hours.
- 10) Re-install the D407-667-205 crosstube per section 32.2 of ICA-D206-667.

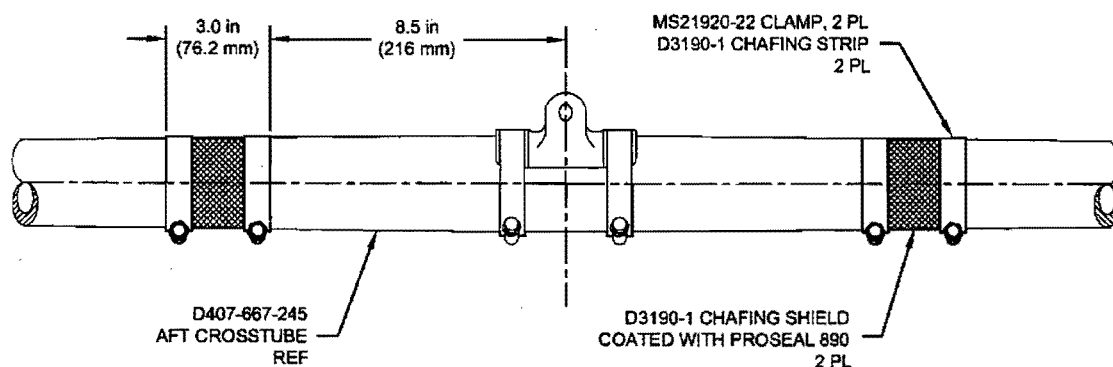
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)  
DATE: 11.04.07  
CERT. NO.: SH01-5  
ISSUE NO.: 3

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DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		DSI 9550	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		D407-667-205 FINISHING CHANGE	NTS
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**FIGURE 1 - INSPECTION WINDOW ON  
D407-667-205 CROSSTUBES**



**FIGURE 2 - CHAFING SHIELD  
INSTALLATION ON D407-667-205**

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